

Ship Nov 12

Work Order ID 62531



Monday, October 04, 2010 10:14:43 AM

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 10/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 11/10/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-10-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Ph →
J. Swilub
J. Swilub 10/11/02

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

M114377
M108436

3-Grind End Plate flush

10-10-26 10

Dart Aerospace Ltd

W/O: 62531		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/10/09	# 100	Perm. change ADD Qty + length for D7856-400 in Pick list	MA	10.11.04			S 10/10/09	

Part No: D350-591-312 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	BE010/26	
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Ph 10.10.28

10

Ph

180



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Ph 10.10.28

10

Ph

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R ☐ Aluminum Rod M108436

6-Grind End Plate flush

7-Install last rivet as per Dwg.

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

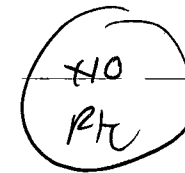


Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				10	0	BE10/10/29	
200 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
210 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10		BR10-11-1.	

S10/10/29



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Page 5

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Start Date:	10/4/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	11/10/2010	Req'd Qty:	10.00		Customer:	

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M.115291.</i> Memo START TIME: <i>2:40</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>3:10.</i>	0.00 0.00							<i>10. RH BR 10-11-1</i>
230  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M115790.00</i> Memo	0.00		<i>ul 10/11/01</i>		<i>x10</i>	<i>0/</i>		
240  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>51010102</i>		<i>710</i> <i>PH</i>			

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Packaging Packaging	Pick Kit Memo	0.00 0.00							
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
270 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD350-591-312 Location: _____	0.00 0.00							

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 7

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CL 10/11/03. JF
MF
10-1F3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, October 04, 2010 10:14:47 AM

Abstract



Required Qty: 10.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3067-1 		Manufactured	No			110	Each	72.0000	1	10		10.10.25	
End Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				72					
					60141			72					
D3272-1 		Manufactured	No			110	Each	15.0000	1	10		10.10.22	
Step													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA	362534			15					
					62134			15					
D3065-041 		Manufactured	No			180	Each	43.0000	1	10		10.10.28	
Step Leg Assembly Hi													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				43					
					60200			14					
					61216			29					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Monday, October 04, 2010 10:14:47 AM

Work Order ID: 62531

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No

180 Each

83.0000

2

20



Spacer

Location

Loc Qty

Loc Code

WA

83

60194

35

61205

48

D3067-1 Manufactured No

180 Each

72.0000

1

10



End Plate

Location

Loc Qty

Loc Code

WA

72

60141

72

D3219-1 Manufactured No

180 Each

141.0000

2

20



Plate

Location

Loc Qty

Loc Code

WA

141

60859

27

61204

114

MS20600-AD4W4 Purchased No

180 Each

1,699.000

16

160



Rivets

Location

Loc Qty

Loc Code

ST321

1699

113368

62

114181

11

114718

2

115573

624

115640

1000

Monday, October 04, 2010 10:14:47 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Monday, October 04, 2010 10:14:47 AM

Page 3

Work Order ID: 62531

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN3-35A

Purchased

No

250

Each

90.0000

2

120



10/11/2010

Bolt

Location

Loc Qty

Loc Code

ST353

90

115108

40

115457

50

AN4-13A

Purchased

No

250

Each

480.0000

8

80



10/11/2010

Bolt

Location

Loc Qty

Loc Code

ST358

480

115159

480

AN5-36A

Purchased

No

250

Each

97.0000

2

20



10/11/2010

Bolt

Location

Loc Qty

Loc Code

ST341

97

114292

5

114941

92

AN960JD10 1

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

40



10/11/2010

Washer

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased No

250 Each

24.0000

16 160



Washer

Location

Loc Qty

Loc Code

ST300

24

113288

24

AN960JD516 NAS1149D0563J Purchased No

250 Each

34.0000

4 40



Washer

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D2230-3 Manufactured No

250 Each

70.0000

4 40



Lug

Location

Loc Qty

Loc Code

ST476

70

55452

2

60846

68

D2618 Manufactured No

250 Each

83.0000

2 20



Bushing

Location

Loc Qty

Loc Code

ST019

81

60772

81

ST020

2

56892

1

57829

1

Monday, October 04, 2010 10:14:47 AM

Shop Packet Print

Page 4

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Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

D2856-400 Manufactured No

250 f

276.3760 0.6



Abraison Strip

Location

Loc Qty

Loc Code

ST403

276.3760421

56626

63.2560421

59920

213.12

D3235-1 Manufactured No

250 Each

57.0000 2



Mounting Lug

Location

Loc Qty

Loc Code

ST471

57

60490

17

60851

40

D3278-041 Manufactured No

250 Each

57.0000 1



Support Assembly

Location

Loc Qty

Loc Code

ST471

57

60201

17

61212

40

MS21042L3 Purchased No

250 Each

1,720.000 2



Nut

Location

Loc Qty

Loc Code

ST300

1720

114523

49

114784

1671

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Start Date: 10/4/2010

Required Date: 11/10/2010

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

250

Each

4,434.000

8

80



10/11/2010

S Nut

Location

Loc Qty

Loc Code

ST300

4434

113422

68

114523

8

114718

16

114784

32

115108

1310

115589

1900

115621

1100

80

MS21042L5

Purchased

No

250

Each

899.0000

2

20



10/11/2010

(102)

S Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

873

115156

373

115594

500

20

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DART

DESIGN <i>CP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
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SUBJECT TO APPROVAL

NO

42531
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

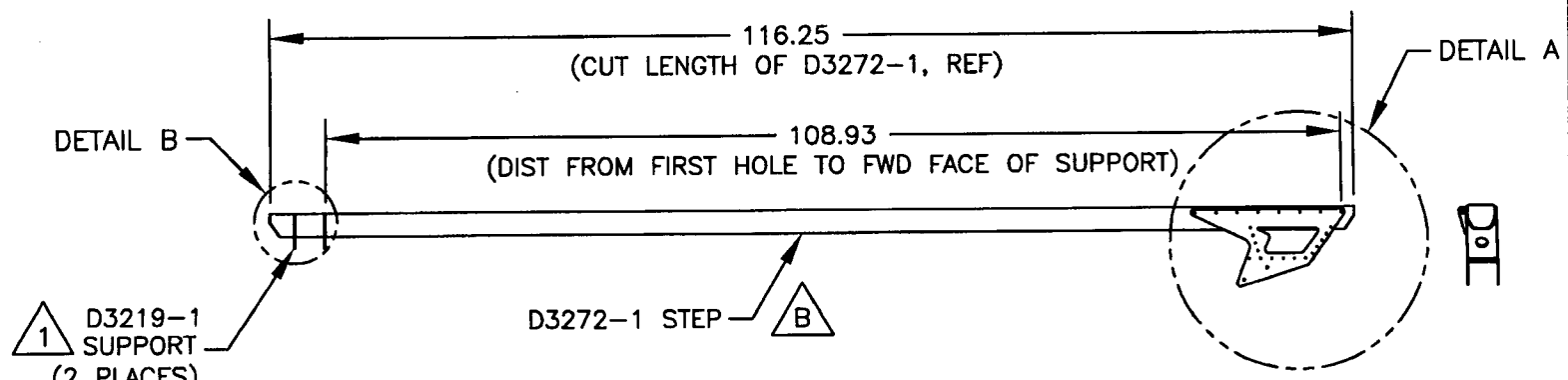
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

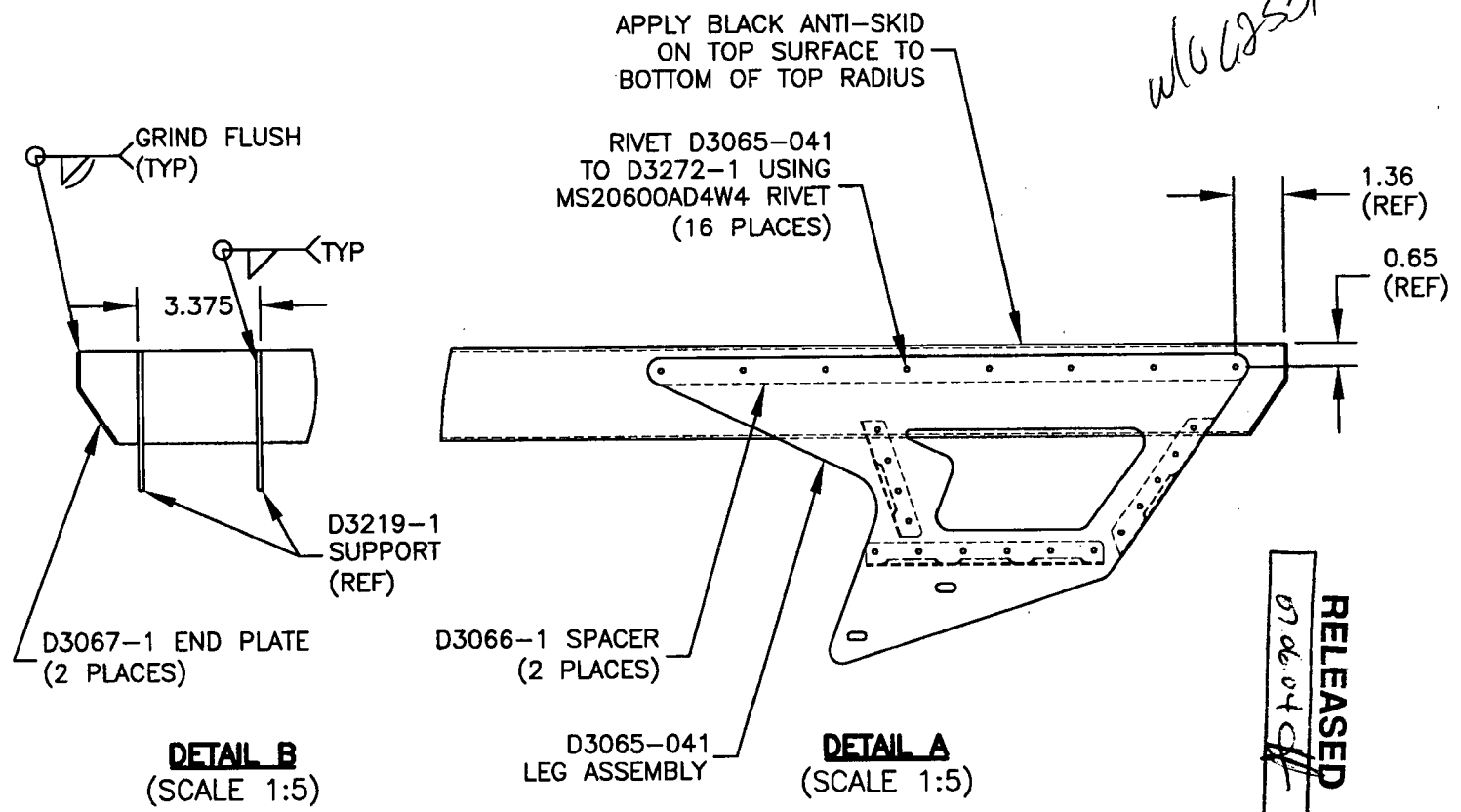
DART

DESIGN	00	DRAWN BY	07.05.18
CHECKED	CE	APPROVED	
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG
		DRAWING NO.	D3272
		SHEET 2 OF 3	
		SCALE	1:20

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

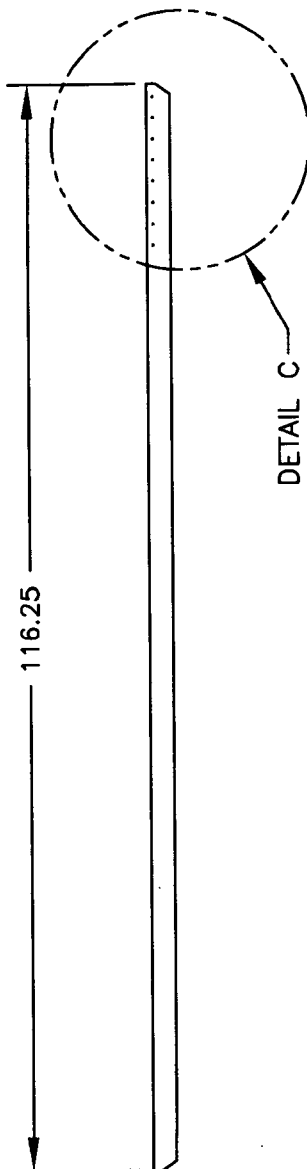
NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>js</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>js</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

07.06.04 *js*

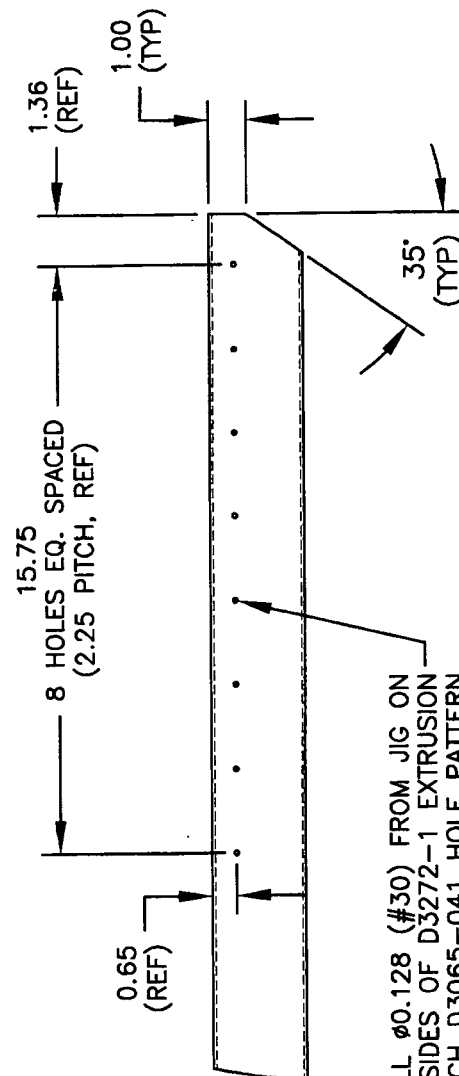


DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)

1337 0/2



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.